

Date: Thursday, 7/19/2007 4:14:44 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM ASS'Y	
Job Number	: 33581				
Estimate Number	: 11734				
P.O. Number	: N/A		Part Number	: D2795041	
This Issue	: 7/19/2007		S.O. No.	: N/A	
Prsht Rev.	: NC		Drawing Number	: D2795 REV A	
First Issue	: 7/17/2007		Type	: SMALL /MED FAB	
Previous Run	: N/A		Project Number	: N/A	
Written By	:		Drawing Revision	: A	
Checked & Approved By	:		Material	: N/A	
Comment	: Est. A 01.02.05 New issue EC		Due Date	: 8/10/2007	
			Qty:	21	Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D27951	Arm LH
Comment: Qty.: 1.0000 Each(s)/Unit Total : 21.0000 Each(s) Arm LH Pick: Qty Part Number Description Batch 1 D2795-1 Arm B33581 x 19 , B33854 x 2 my mf		
2.0	D2808	Spacer
Comment: Qty.: 1.0000 Each(s)/Unit Total : 21.0000 Each(s) Spacer Pick: Qty Part Number Description Batch 1 D2808 Spacer B34034. mf 07-08-28		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2808 into D2795-1 arm as per Dwg D2795 SAD 07/08/28 mf 07-08-28		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP ↗ 07/08/29 x 21 ps		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>5K</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/09/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Q21

Comment: FINAL INSPECTION/W/O RELEASE

7/19/08/30

Job Completion



7/19/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>10</i>		DRAWN BY <i>John</i>		DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>10</i>		APPROVED <i>John</i>		DRAWING NO.	REV. A
DATE 00.11.03		TITLE ARM		D2795	SHEET 1 OF 1
A	00.11.03	NEW	ISSUE		SCALE 1:3

RELEASER
00.11.13

PRESS FIT D2808 SPACER (1)

USE D2795-1 FOR D2795-041
USE D2795-2 FOR D2795-042

D2795-041 (SHOWN)
D2795-042 (OPPOSITE)

1.000

R0.030

Ø0.191 (TOOLING HOLE)

6.049

2.311

9.358

2.033

Ø0.507 ^{0.000} _{-0.001}

0.250(TYP)

0.471(TYP)

Ø0.191

R0.300(TYP)

1.000

2.500

1.347

14.803

FILLET INSIDE OF ALL POCKETS WITH R0.125

C'BORE Ø0.507 ^{0.000} _{-0.001}
0.250 DEEP
FROM THIS SIDE

R0.125 (TYP, REF)

0.250

0.500

R0.032

C'SINK Ø0.375 x 100°

D2795-1 (SHOWN)
D2795-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2795-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP DRAWING
RETURN TO
ENGINEER
MATERIAL
DEBURR
TOLERANCE
NOT CONTROLLED (COP)
SUBJECT TO AGREEMENT
WHICH IS IN THE
SUBJECT TO AGREEMENT

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